

Work Order ID 101458-2 SP/17

May-13-13 12:40:06 PM

101458

Page 1

Item ID: D3065-5

Revision ID:

Item Name: Step Leg

Start Date: 5/13/13

Required Date: 5/20/13

Reference:

Start Qty: 160.00

Req'd Qty: 160.00

160

160

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: ML9

Date: 13-05-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

100

Waterjet

FLOW CNC Waterjet

6061-080

FLOW WATER JET

0.00

Memo

0.00

1-Cut as per Dwg D
if necessary

Dwg Rev: B

Prog Rev: B

2-Deburr

117

0

Jm13-5-21

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

117

0

Jm13-5-21

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

SMB
13522

117

can

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101458

Page 2

Item ID: D3065-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Leg

Start Date: 5/13/13

Start Qty: 160.00

160

Cust Item ID:

Required Date: 5/20/13

Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

69 7/13-6.6

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

69 7/13/06/10

150

Identify as per dwg & Stock Location: G-A

0.00

150

Packaging

Memo

0.00

Packaging

69 7/13/06/10

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101458

Page 3

Item ID: D3065-5

Accept

N9000040100

Setup Start

NS1

Revision ID:

Item Name: Step Leg

Stop

NS2

Start Date: 5/13/13

Start Qty: 160.00

160

Cust Item ID:

Required Date: 5/20/13

Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/6/11

MF

13-6-70

Picklist Print

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Page 1

Work Order ID: 101458

101458

Parent Item: D3065-5

D3065-5

Parent Item Name: Step Leg

Start Date: 5/13/13

Required Date: 5/20/13

Start Qty: 160.00

Required Qty: 160.00

Comments:

IPP: C02.11.01 Incorporated D3066-1 IPPKJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	112.5973	0.825	138.9474			
M6061T6S 080									**	96.112.1			JMB-S-17
6061-T6 .080 Sheet													

Location

MAT021

Loc Qty

112.597264

Loc Code

~~117285~~
124786

~~0.497264~~
112.1

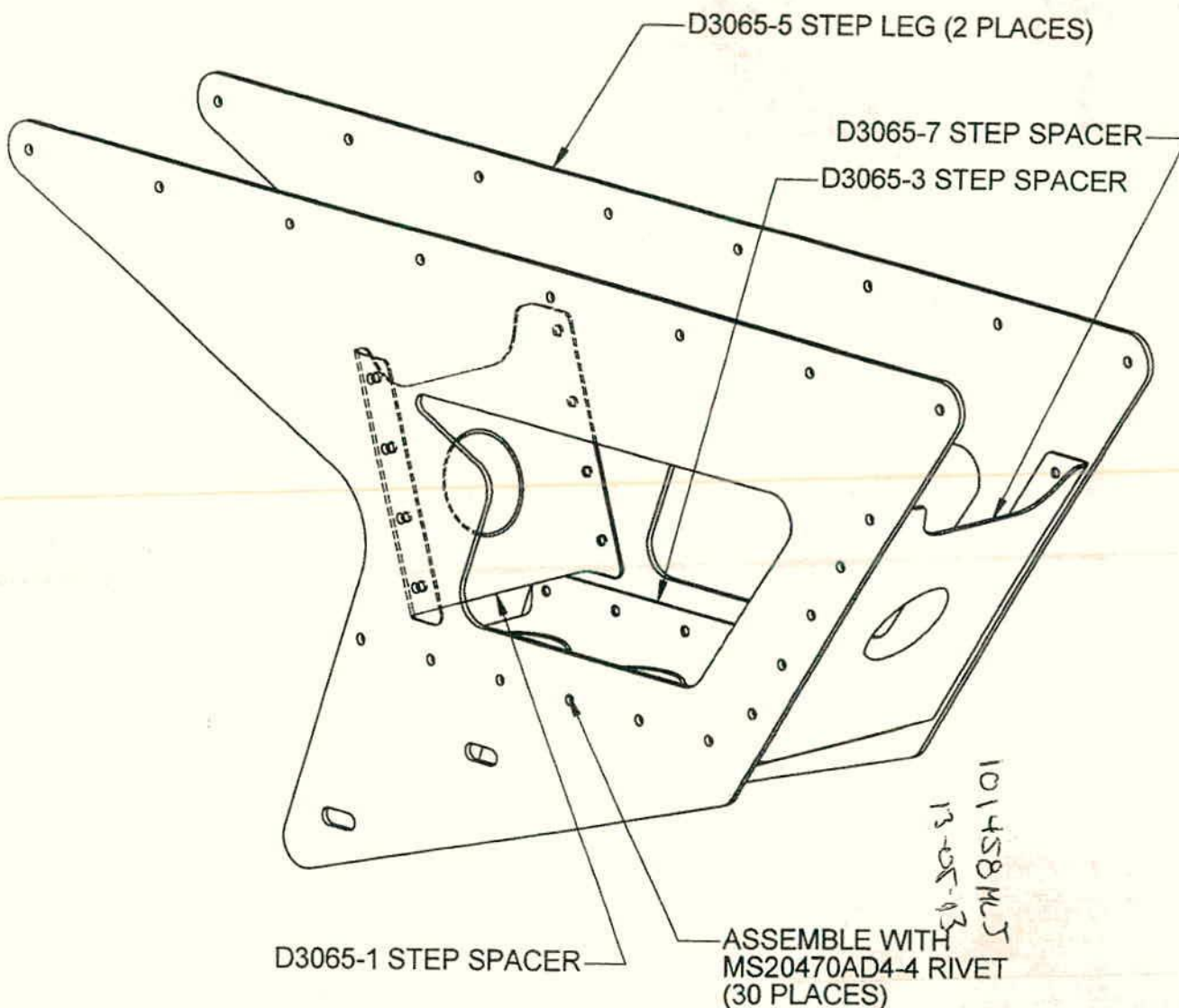
~~112.1~~ 96 S.F.



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SHEET 1 OF 5 SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



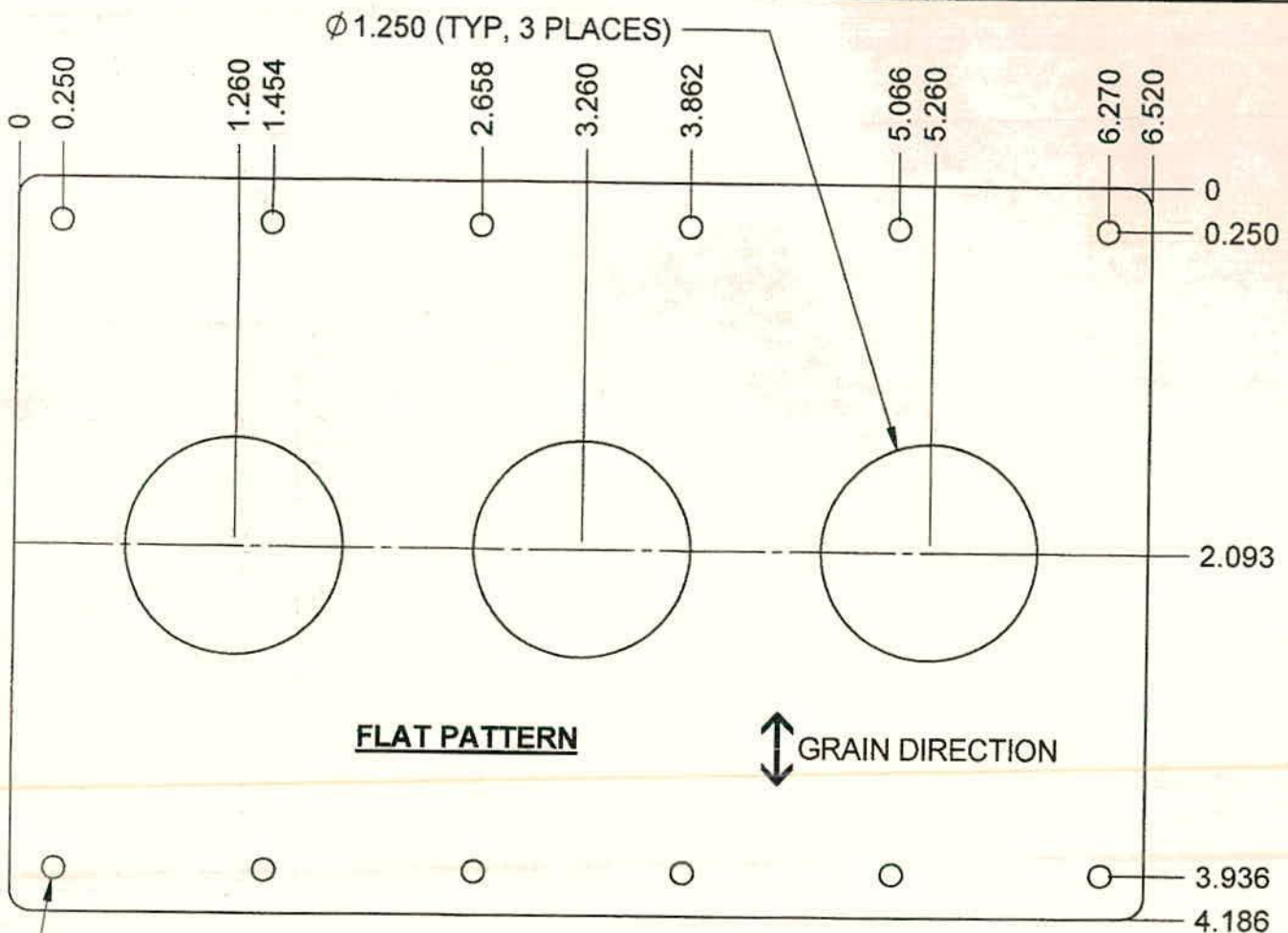
D3065-041 STEP LEG ASSEMBLY

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		
			SCALE 1:1

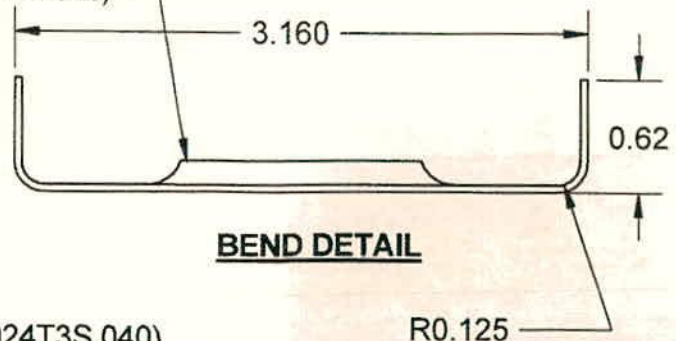


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø0.129 (TYP, 12 PLACES)

RELEASED

06/06/20 *[Signature]*



D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

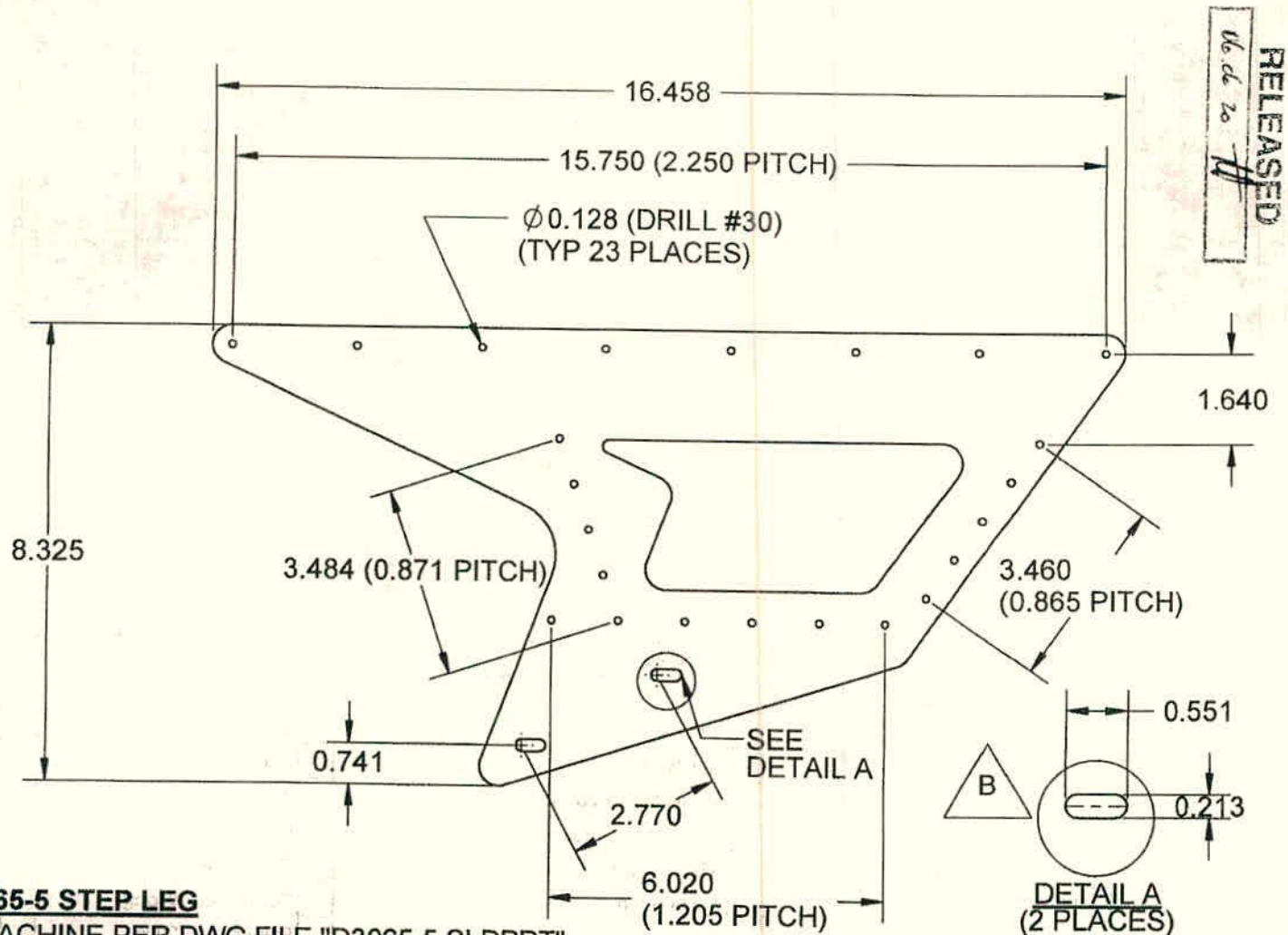
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25/10/1



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. B
04	06	D3065
DATE	TITLE	SHEET 4 OF 5
06.05.23	STEP LEG ASSEMBLY	SCALE 1:3



D3065-5 STEP LEG

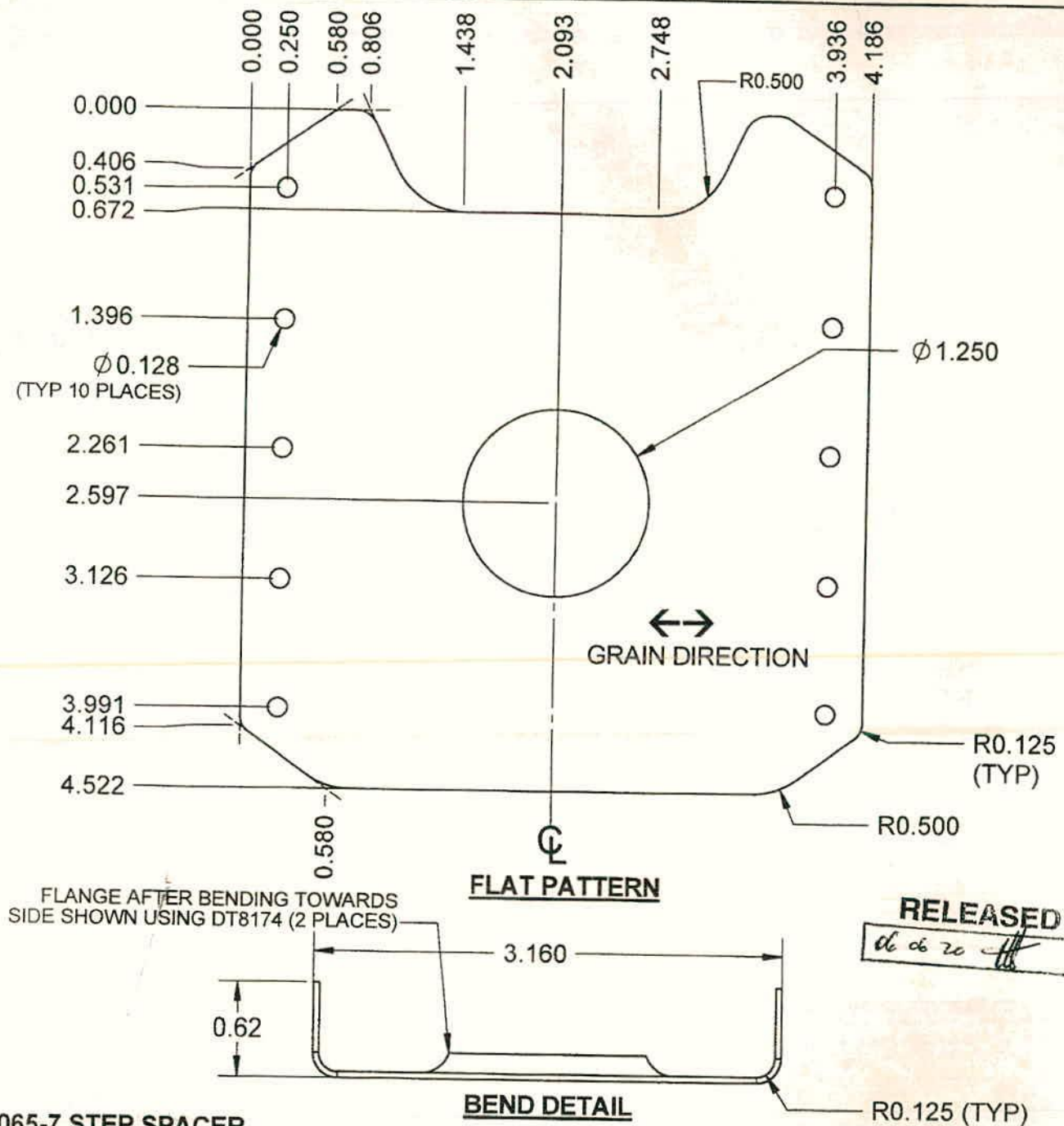
- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

**D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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